

Date: Thursday, 16/10/2008 10:44:13 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 42628B		
Estimate Number	: 10207		
P.O. Number	:	Part Number	: D2989043
This Issue	: 16/10/2008 S.O. No. :	Drawing Number	: D2989 REVC
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 42625B	Material	:
Written By	:	Due Date	: 05/11/2008 Qty: 1 Um: Each
Checked & Approved By	JUD 08.10.16		
Comment	Est Rev:I Removed D2989-041 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31821	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

✓	Qty Part number	Description	Batch
	2 D3182-1	Hinge	B39336

HY 08/11/14

2.0	D34423	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

✓	Qty Part number	Description	Batch
	2 D3442-3	Shim	B42718

HY 08/11/14

3.0	M304EX07516F	Expanded Metal Flat SS
-----	--------------	------------------------



Comment: Qty.: 8.0000 sf(s)/Unit Total: 8.0000 sf(s)

Pick:

✗	Qty Part number	Description	Batch
	8sf M304EX0.75-16F Expanded Metal		m109383

SAD 08-11-13

①

4.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------



Comment: Qty.: 17.6400 f(s)/Unit Total: 17.6400 f(s)

3/4" x 3/4" x 0.065" wall 304/316 SS tubing.

Batch: m109731

SAD 08/11/10

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 42628B

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

JS 08/11/17

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

JPC 08-11-18

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5 08/11/18

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Plug holes in D2989-17 and D2989-2 prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:45
400 OF
9:15
10:00
400 OF
10:30

M-1 08/11/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 42628B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

58/11/20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/24

Job Completion



MF 08-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D2989-041	BASKET LID ASSEMBLY
	X	D2989-043	BASKET LID ASSEMBLY
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2	2	D2989-17	STRUT
2		D2989-19	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

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08-06-2017

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING TRANSFERED TO "B" SIZE FORMAT & CURRENT DRAFTING STANDARD.	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2989	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.06.20	COPYRIGHT © 2000 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8

7

6

5

4

3

2

1

SKIN BASKET LID WITH 3/4-16F
EXPANDED SS, TACK WELD EACH
END STRAND TO EXTERNAL FRAME

D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" x 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

D1-2
SEE DETAIL C
2 PL

TACK WELD EVERY
2ND STRAND TO
INTERNAL FRAME
MEMBERS

D2989-11
REF

BLACK ANTI-SKID
PAINT THIS SECTION

30.00

34.50

30.00

REF

D2989-17

SEE DETAIL B A1-2

D2512-7

D2989-19

D2989-12

D2989-19

D2989-13

D2989-17

D2989-13

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKID'D

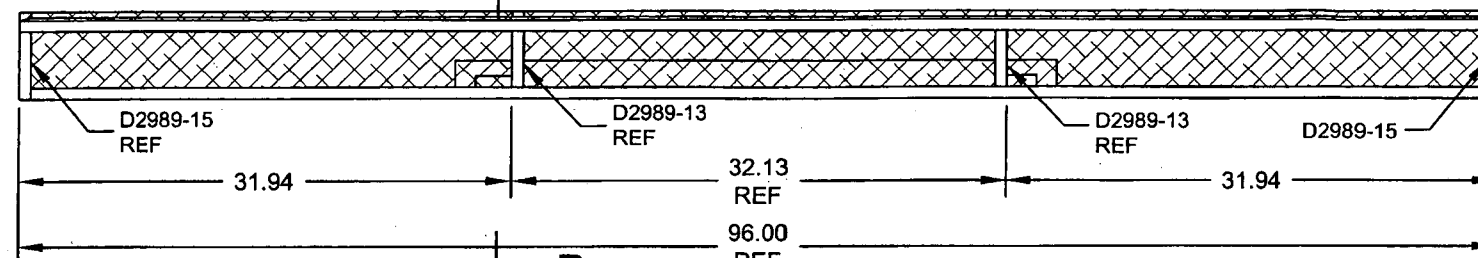
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REF

Ø0.257
D2989-11

D2989-15

D2989-9



D2989-041 LID ASSEMBLY

SEE DETAIL A
B1-2

D2989-17

TACK WELD EVERY 2ND
STRAND TO INTERNAL
FRAME MEMBERS

D2989-3
REF

Ø0.257
5 PL

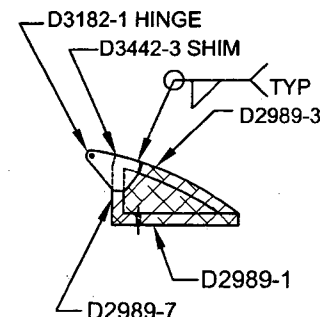
D2989-17

D2989-5

D2989-5

SKIN BASKET LID WITH 3/4-16F
EXPANDED SS, TACK WELD EACH
END STRAND TO EXTERNAL FRAME

D2989-4



DETAIL E
A8-2

1.75
2 PL

31.94

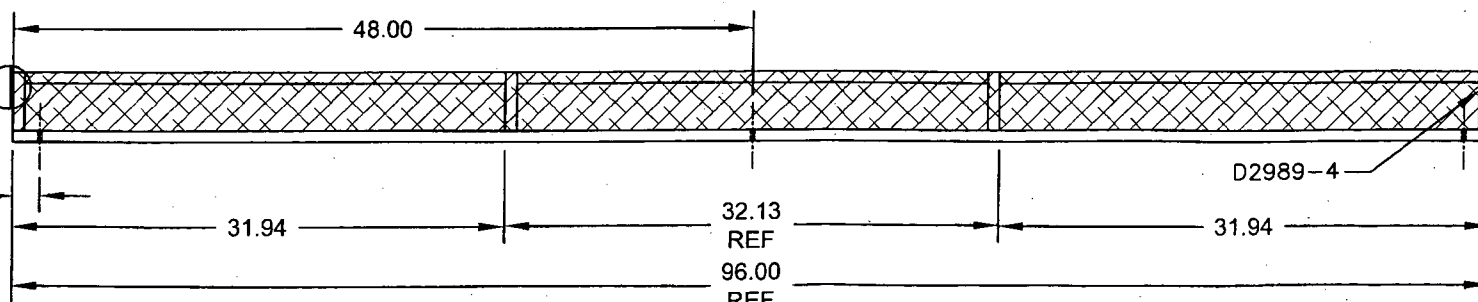
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REF

96.00

REF

D2989-4

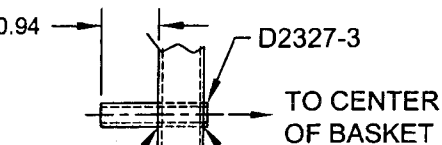


D2989-043 LID ASSEMBLY

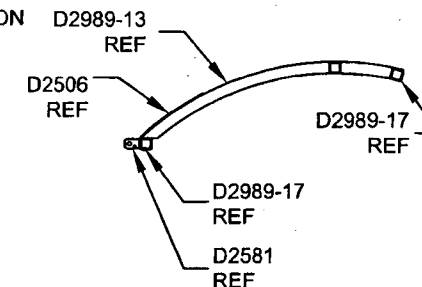
D3182-1 HINGE

DETAIL E B7-2
SCALE 5X
(BOTH ENDS)

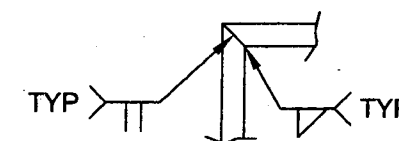
D3442-3 SHIM



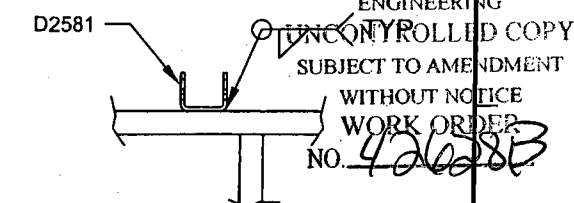
DETAIL C D7-2
SPACER INSTALLATION
SCALE 4X



SECTION D-D C5-2



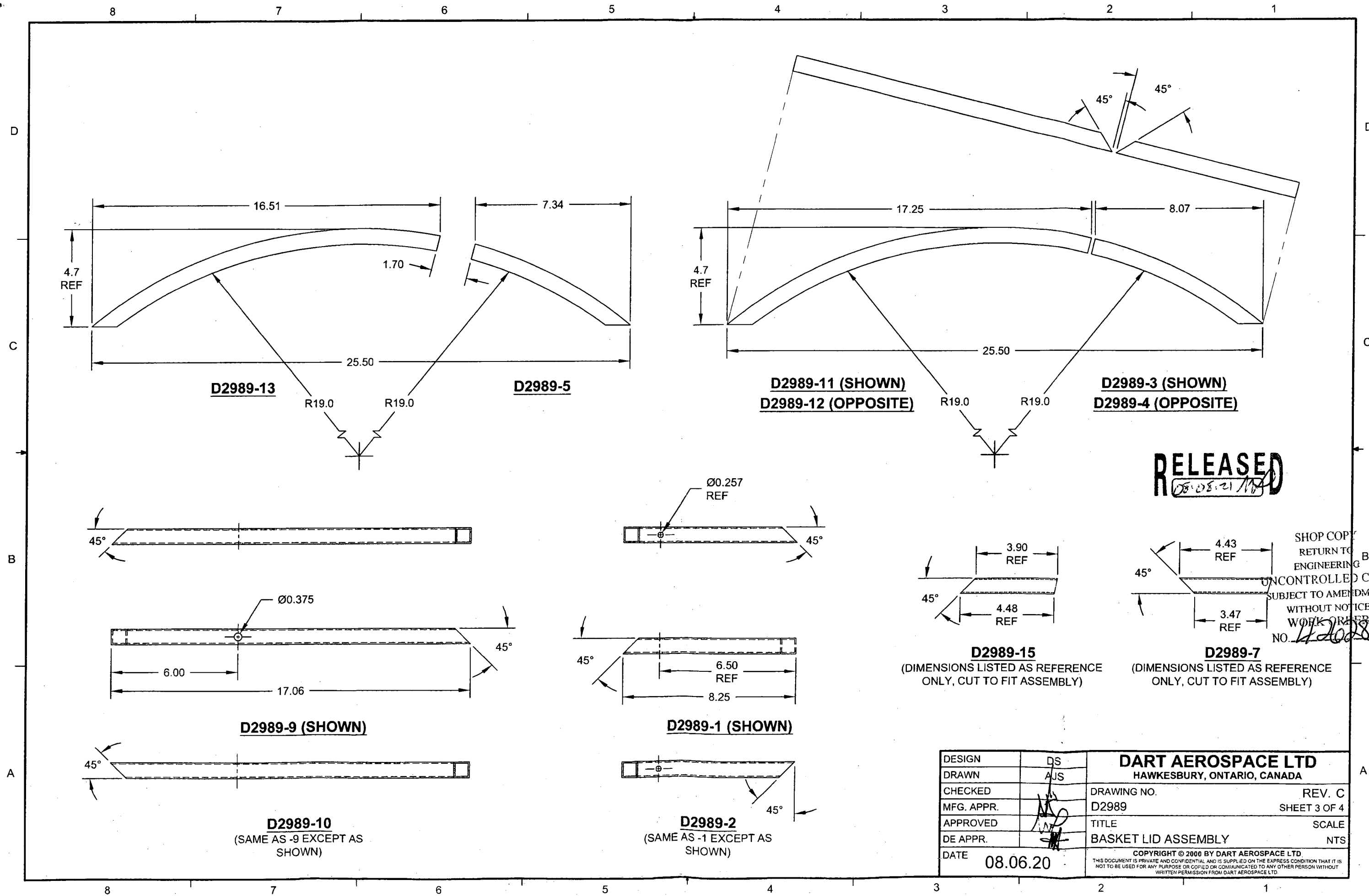
DETAIL A B7-2
WELD ALL JOINTS
AS SHOWN
SCALE 2X



DETAIL B D4-2
SCALE 2X

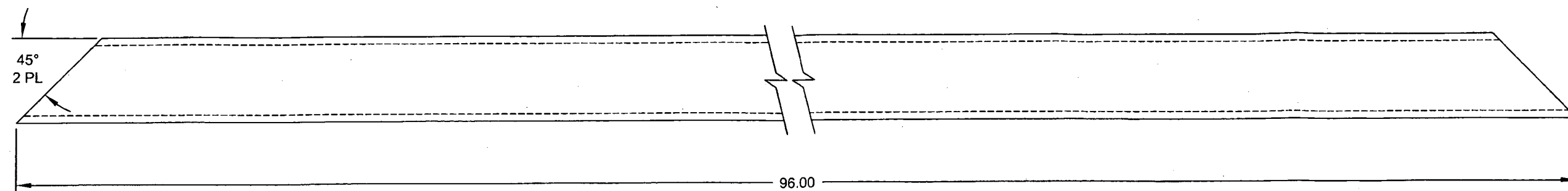
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08.06.20



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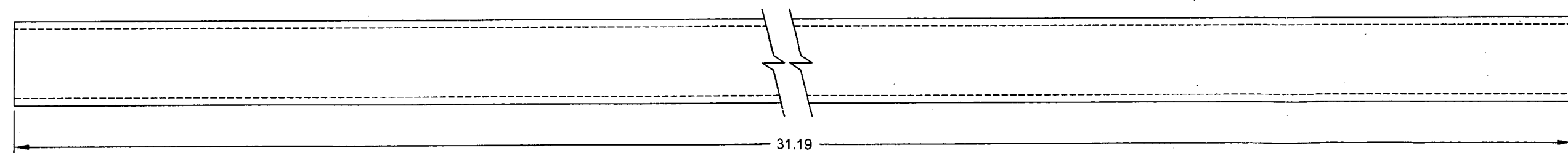
D



D2989-17 STRUT

C

B



D2989-19 STRUT

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08.08.21/111

A

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8 7 6 5 4 3 2 1

